Work Order ID 113592 \*113592\* Page 1 February-24-14 9:59:04 AM Item ID: D3488-042 Accept \*N900040100\* Setup Start **Revision ID:** \*NS2\* **Item Name:** Blade Fitting RH **Start Date:** \*12\* **Start Qty: 12.00** 2/24/14 **Cust Item ID:** Required Date: 2/24/14 Req'd Qty: 12.00 Customer: \*12\* Reference: Run Process Plan: MC5 Date: 14-02-24 Tooling: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Reject Reject Set Up/ Tool ID Insp. Accept . Work Center ID Description Number Stamp **Run Hours** Code Qty Qty Draw Nbr **Revision Nbr** D3488 Rev B **DSK 101 REV D** 100 0.00 10 8 DOOSAN LATHE \*100\* Doosan 0.00 Memo Doosan Lathe 1-Turn as per Dwg DSK 101 & Folio FA625 2-Deburr

0.00

0.00

14/02/28

-110

\*110\*

**Quality Control** 

QC2- Inspect parts off machine FAI/FAIB

Memo

Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training	DQA:			Date:		<del></del>				_				TRAGG
DISPOSITION   Rework   Scrap   Use-as-is   Suspected Unapproved   NCR No.   Description of work order update   Initial   Action   Cause   Date   Step   Qty   Description of work order update   Chief Eng   Description   Descr							WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA				AEROSPACE
Rework   Scrap   Use-as-is   Suspected Unapproved   Suspection Unap	QA Closed:			Date:							W	ork Order up	date only	
Rework Scrap Use-as-is Suspected Unapproved  Root Cause Date Step Qty Description of work order update or non-conformance  Design Operator Obset/Stup Process   Disperoved Description Des	Work Orde	r:					DISPOSITION			A	GAINST DE	PARTMENT/	PROCESS	
Part No. Scrap Use-as-is Suspected Unapproved Unapprove		•					Rework	l		Skid-tube Cr	rosstube		Water Jet	Engineering
NCR No.    Use-as-is   Suspected Unapproved   Large Fab   Composite   Supplier   Other	Part N	o.								<b>—</b>		Prod	<b>⊢</b>	→ ` <u>-</u> —
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Handling/Pre Handling/Pre Unapproved Drevess' Drevess' Drevess' Dransport Unapproved Drevess'		•					Use-as-is		Thern	noforming F	inishing	Rec/Stor	e/Packaging	Other
Date   Step   Qty   Or non-conformance   Chief Eng   Description   Date   Verification   QC Inspector	NCR N	o.					Suspected Unapproved			Large Fab Cor	mposite	]	Supplier	
Design Doc/Data Equip/Tooling Lauip/Tooling Handling/Pre	Root					Desc	ription of work order update		nitial	Action		Sign &		
Doc/Data   Equip/Tooling   Handling/Pre   Handlin	Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector
Handling/Pre Material Operator Offset/Setup Process 7	Design													
Handling/Pre Material Operator Offset/Setup Process '	Doc/Data			l										
Material Operator Offset/Setup Process 1	Equip/Tooling	_						1						
Operator Offset/Setup Process 7	Handling/Pre													
Offset/Setup Process Supplier Training Transport Unapproved  Landing Gear  Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Crimp/Kink/Ripple/Wave Cuffs Custing Cu	Material	_												
FAULT CATEGORY  Landing Gear  General  Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Crimp/Kink/Ripple/Wave Cuffs Cuffs Cuffs Contamination Crushing Countersink Crushing Countersink Circushing Countersink Circushing Countersink Circushing Countersink Circushing Countersink Circushing Cuffs Cuffs Cuffs Cuffs Cuntersink Cuffs Cuntersink Cuffs Cuffs Cuffs Cuffs Cuffs Cuffs Cuntersink Cuffs	Operator	_												
Training   Transport   Unapproved   FAULT CATEGORY   FAULT CATEGORY   Training   Transport   Unapproved   FAULT CATEGORY   Training   Transport   Unapproved   FAULT CATEGORY   Training   Transport   Transpor	Offset/Setup	_												
Training Transport Unapproved PAULT CATEGORY    Landing Gear	Process	_												
Transport Unapproved	Supplier	4	; 											
Landing Gear   General	Training	4												
FAULT CATEGORY  Landing Gear  General  Bending  Centre Not Concentric  Cracks  Broken/Damage/Defect  Crimp/Kink/Ripple/Wave  Cuffs  Countersink  Crushing  Cut Too Short  Inspection Strip in Tube  Capical  Folio/Program  Folio/Program  Folio/Program  Outside Dimensions  Pressure/Forced  Set-up  Part Incorrect  Part Incorrect  Temperature/Cure  Inspection Incomplete/Unqualified  Instructions Incomplete/Unclear  Misaligned/off center  Mislabeled  Misread  Misread	Transport	_												
Landing Gear  Bending Bend Centre Not Concentric Cracks Broken/Damage/Defect Crimp/Kink/Ripple/Wave Couffs Countersink Crushing Countersink Cut Too Short Inspection Incomplete Inspection Strip in Tube Cut Too Short Inspection Centre Not Concentric BoM/Route Grain Cover/Under tolerance Over/Under tolerance Cover/Under tolerance Cover/Under tolerance Cover/Under tolerance Inspection Incomplete/Unqualified Part Incorrect Part Lost/Missing Part Moved Wrong Stock Pulled Positioned Wrong Power Loss/Surge Other  Misslabeled Misread	Unapproved			L				<u> </u>						
Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread								FA	ULT CA	IEGORY				
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Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Cuffs Contamination Instructions Incomplete/Unclear Part Lost/Missing Weld Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other  Inspection Strip in Tube Drawing Misread				ot Concer	TUTIC		<b>₫</b>	$\vdash$	4			1	<u> </u>	<b>⊣</b>
Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other  Inspection Strip in Tube Drawing Misread		$\overline{}$		d /Binnlo	Mayo	$\vdash$	1	$\vdash$	ł		ified	4	·····	
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread		_		ik/kibbie	y wave	$\vdash$	i	$\vdash$	1 .	•	<del></del>	-		
Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread			l						4	•	d1	4		
Inspection Strip in Tube Drawing Misread			1	.+		-		-	1		$\vdash$	4		Other
			•		Tube	-	-	-	1		L	J. OWC. 1033/.	- Jui 80	Tourci
Interest		_		-	Tube			-						
Turning Sequence Finish Out of Calibration			<b>t</b>			$\vdash$		$\vdash$	-					
Wave/Twist in Tube   Fit/Function   Out of Sequence			1	-				$\vdash$	-					

Work Order ID 113592 \*113592\* Page 2 February-24-14 9:59:04 AM D3488-042 Accept **Item ID:** \*N900040100\* Setup Start **Revision ID: Item Name:** Blade Fitting RH \*12\* **Start Date:** 2/24/14 **Start Qty: 12.00 Cust Item ID:** Required Date: 2/24/14 Req'd Qty: 12.00 \*19\* Customer: Reference: Run **Tooling: Approvals:** Process Plan: Date: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Qty Qty Number Stamp **Work Center ID Description Run Hours** Code 0.00 120 <u>at</u> 14-03-HAAS CNC VERTICAL MACHINING #1 \*120\* 0.00 HAAS 1 Memo HAAS CNC vertical machine #1 1-Machine as per Folio FA627 & Dwg D34882-Deburr QC2- Inspect parts off machine FAI/FAIB 0.00 130 \*120\* 0.00 QC Memo **Quality Control** 

140

QC8- Inspect parts - second check

Memo

0.00

\*140\*

QC

0.00

**Quality Control** 

10 \_ Ø \_

2014-03-18

DQA:		<del></del>	Date:			WORK ORDER NON-	-CC	NIEOI	PNANCE / I	IDDATE				_	DART
QA Closed:			Date:			WORK ORDER WORK		NIFOI	NIVIAIVEL / C		Wo	ork Order up	date only		AEROSPACE
Work Orde	·r·					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
WOIK Olde	-	<del> </del>	•			Rework	ı		Skid-tube	Crosstube			Water Jet	$\neg$	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	$\neg$	Quality
	•					Use-as-is			noforming	Finishing		Rec/Stor	e/Packaging	٦	Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		nitial	Ac	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	$\sqcup$	QC Inspector
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:		Centre No	ot Concei	ntric		BOM/Route	$\vdash$	Grain				Over/Under		_	Set-up
		Cracks		-		Broken/Damage/Defect	$\vdash$	Hardwa	are		-	Part Incorre		$\dashv$	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/l	Unqualified		Part Lost/Mi	ssing		Weld
	Ι.	Cuffs	, , , , , ,	-		Contamination		1 '	tions Incomplete	•		Part Moved	<u>-</u>		Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	Г	4	gned/off center			Positioned V			
		Heat Trea	at			Cut Too Short		Mislab	-	:		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d			•	_		
		Marks/Cl				Drill Holes		Off-set					<del>-</del>		
1		Turning S	equence			Finish		Out of	Calibration						
!		Wave/Tu	ist in Tul	he		Fit/Function		Out of	Sequence						

Wo	rk	Order	ID	113592
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**Quality Control** 

\*113592\*

Page 3 February-24-14 9:59:04 AM D3488-042 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Stop **Item Name:** Blade Fitting RH \*19\* **Start Date:** 2/24/14 **Start Qty: 12.00 Cust Item ID:** Required Date: 2/24/14 Req'd Qty: 12.00 \*12\* Customer: Reference: Start Run **Approvals:** Process Plan: Date: Tooling: Date: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: \*NP2\* Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Code Qty Number Stamp **Run Hours** Qty 150 Chemical Conversion Coat per QSI005 4.1 0.00 10 16/43-19 \*150\* HandFinish 0.00 Memo Hand Finishing 160 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 10 \$ 143-24 853 \*160\* Powdercoat 0.00 OVEN TEMPERATURE: **Powder Coating** QC3- Inspect Part Finish 170 0.00 10RH d M 1.1/03/26 \*170\* 0.00 Memo

DQA:			Date:										
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
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, work ora						Rework			Skid-tube Crosstu	be	1	Water Jet	Engineering
Part N	No.					Scrap			Machining Small F		Pro	d. Eng. Coor.	Quality
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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	$\vdash$	Cracks	or concer	iti ic	-	Broken/Damage/Defect		Hardwa	ara	$\vdash$	Part Incorred	<u> </u>	Temperature/Cure
<u>'</u>	$\vdash$	Crimp/Ki	nk/Rinnle	/Wave		Burrs	$\vdash$	1	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	<b> </b>	Weld
	$\vdash$	Cuffs	путпрыс	, wave	H	Contamination		1	tions Incomplete/Unclear	$\vdash$	Part Moved	-	Wrong Stock Pulled
	$\vdash$	Crushing				Countersink	$\vdash$	4	gned/off center	-	Positioned V	L. Vrong	
	$\vdash$	Heat Trea				Cut Too Short		Mislab		F	Power Loss/		Other
		Inspectio		Tube		Drawing		Misrea		_	J. 5115, 2530/		1
	-	Marks/Cl	-			Drill Holes		Off-set					
		Turning S				Finish		4	Calibration				
		Wave/Tw				Fit/Function		-1	Sequence				

<b>Work Ord</b> February-24-14					*119	3592*				b.A**		Page 4
Item ID:	D3488-042			A	Accept	*N90	<u>)</u>	1100	<b>)*</b> s	etup St	art *N	S1*
Revision ID:	D. 1 Et.: 1	n.r.								St	op <b>+N</b> !	S2*
Item Name:	Blade Fitting l										!/	<b>ラン</b> "
Start Date:	2/24/14	<b>Start Qty:</b> 12.00		*12*		Cust It	em ID:					
Required Date	e: 2/24/14	Req'd Qty: 12.00		*12*		Custon	ner:					
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Approvals:	Process Pla	nn:	Date:		Tooling:		Date:		R			R1*
**			Date:		SPC (Y/N):		Date:			St	top <b>*N</b> i	R2*
	<b>Q</b> c				010 (1/11)							
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Tool	ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180					0.00					/	ΔΛΛ	1 /
*120*		HandFinishing							10RH	d	<u>II</u>	10/03/25
HandFinish		Memo			0.00					1		
Hand Finishing		Install Insert	s as per D	wg D3488								
190		QC5- Inspect part comple	eteness to	step on W/O	0.00							<b>8</b> 8 8 8
*190*									10 a	S /	13:26	. 60
QC		Memo			0.00				7			
Quality Control												
200		Identify as per dwg & Sto	ock Locat	ion: <u>FP-0</u> 0 (	0.00						/ -1	NA 1 7
*200*									X 108	211 /	او کم	1(163)-
71111					0.00				<u> </u>	(		~ <del></del>

0.00

Memo

\*200\* Packaging

Packaging

DQA:			Date:										TQAC <sup>2</sup>
						<b>WORK ORDER NON-</b>	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ır.					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orde	-					Rework	1		Skid-tube Crosstube	Г		Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is	1		noforming Finishing		•	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desc	ription of work order update	l	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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· ·		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Work Order ID 113592 \*113592\* February-24-14 9:59:04 AM Accept \*N900040100\* D3488-042 Setup Start Item ID: **Revision ID:** Stop Blade Fitting RH **Item Name:** \*12\* **Start Date:** 2/24/14 **Start Qty: 12.00 Cust Item ID:** Req'd Qty: 12.00 Required Date: 2/24/14 \*19\* **Customer:** Reference: Start Run Process Plan: Date: **Tooling: Approvals:** Date: Stop QC: Date:\_\_\_\_\_ SPC (Y/N): Date: Tool # Plan Reject Reject Sequence ID/ Set Up/ Tool ID Accept Operation

\*210\*

210

**Work Center ID** 

Memo

QC21- Final Inspection - Work Order Release

**Description** 

0.00

0.00

**Run Hours** 

Quality Control

- P(14-03-31) MK 3-20

Code

Qty

Qty

Insp.

Number Stamp

Page 5

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:		1					W	ork Order up	odate only	
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	-	<u>.</u>				Rework			Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
,	•					Use-as-is			noforming Finishing	_	1	re/Packaging	Other
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	Щ	Bending			_	Bend		1	Program	_	Outside Dim		Pressure/Forced
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		Cracks			-	Broken/Damage/Defect		Hardw		L	Part Incorre	<del></del>	Temperature/Cure
	Ш	Crimp/Kir	nk/Ripple	/Wave	$\perp$	Burrs	<u> </u>	<b>1</b> '	tion Incomplete/Unqualified	$\vdash$	Part Lost/M		Weld
		Cuffs				Contamination	$\vdash$	,	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing			<u> </u>	Countersink		4	gned/off center		Positioned \		<b>7</b>
	_	Heat Trea			<u> </u>	Cut Too Short	<u></u>	Mislab		L	Power Loss/	Surge	Other
		Inspectio		Tube	<u> </u>	Drawing		Misrea					
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	_	Turning S	-			Finish	$\vdash$	4	Calibration				
		Wave/Tw	ist in Tuk	oe		Fit/Function		Out of	Sequence				

Loc Qty

20

20

Loc Code

Location

**MAT043** 

110129

**-** 112311

Round Billet, Aluminum

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			–	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ar.					DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
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Part N	lo.					Scrap			Machining Small F	-	Pro	d. Eng. Coor.	Quality
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		Centre No	ot Concer	ntric	_	BOM/Route	L	Grain			Over/Under	<u> </u>	Set-up
		Cracks				Broken/Damage/Defect	_	Hardw			Part Incorre	ļ	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave		Burrs	_	<b>1</b> '	tion Incomplete/Unqualified		Part Lost/M	<del>  _</del>	Weld
		Cuffs			<u> </u>	Contamination	<u> </u>	-4	tions Incomplete/Unclear	<u> </u>	Part Moved	<u> </u>	Wrong Stock Pulled
	L	Crushing			<u> </u>	Countersink	<u></u>	4	gned/off center	-	Positioned V	_	٦
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	<u></u>	Mislab		L	Power Loss/	Surge	Other
	<u></u>	Inspectio		Tube		Drawing	$\vdash$	Misrea					
	<u></u>	Marks/Ch				Drill Holes	$\vdash$	Off-set				· · · · · · · · · · · · · · · · · · ·	
	$ldsymbol{f eta}$	Turning S	•		<u> </u>	Finish	$\vdash$	-	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	113592
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept   Reject		Method of Inspection	Comments
			e Section		<u> </u>	
Ø2.150	+/-0.005	2.149	/		Very	040-12
Ø2.780	+/-0.005	2.779	V		5.0	PHD-12
Ø3.125	+/-0.010	3 175			3(	CNC-02
Ø3.346	+/-0.010	3 348	1		1 34	11
0.125 x 45°	+/-0.010 x +/-0.1°	.125				),
8.000	+0.030/-0.000	8.015			31	/1
9.250	+/-0.010	9.250			11	٠,
0.188	+/-0.010	. 190			,,	1.
R0.032	+/-0.010	.032	/		Rad 6	
R0.062	+/-0.010	.062	1		41	
Ø0.297	+0.005/-0.001	798	/		PING	
Ø0.430	+/-0.010	. 432	1		11	
0.100	+/-0.010	.100			VENU	CUC-OZ
0.125	+/-0.010	-132	/			**
2.620	+/-0.010	7.620				* *
3.500	+/-0.010	3.500	/		1-	
1.005	+/-0.010	1,005			( )	٠,
Ø0.484	+0.005/-0.001	.484			Piu G	
1.180	+/-0.010	1,180			VEW	(NC-02
3.150	+/-0.010	3,450	1		и	٠,
3.070	+/-0.010	3,070			ય	
R0.063	+/-0.010	-063			Rad G	

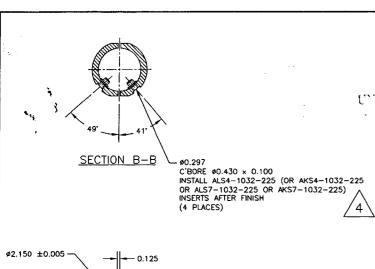
DART AEROSPACE LTD	Work Order:	113592
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

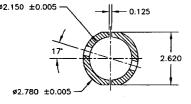
					6.5	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Milli	ng Section	1		
Ø0.508	+0.006/-0.001	0.509				sauge vin
0.750	+/-0.010	0 748			3/006	Height source
1.500	+/-0.010	1 499	/		MJP-04	Versa
11.18	+/-0.030	11,185	/		CNC -02	Ven
R0.062	+/-0.010	0062	/			Radian source
0.125	+/-0.010	0124	/		MJP-04	Vem
0.590	+/-0.010	0.591	/		3/006	Hight cause
0.793	+/-0.010	0 795	1/		MJP-04	VIII
1.351	+/-0.010	1.349	/		3/006	Height and
1.317	+/-0.010	/ 3/9			MJP-04	Vern
1.802	+/-0.010	1805	/		3/006	Weight cours
		,, "				7 3

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	06.03.31	New Issue	KJ/JLM	
В	08.09.19	Reformat P/O D3488-042	KJ/JLM 140	21
С	08.12.02	Dimension 8.000 removed	KJ/JLM 🛠	SM1





SECTION A-A

## D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION		
X		D3488-041	BLADE FITTING ASSEMBLY (LH)		
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)		
1		D3488-1	BLADE FITTING (LH)		
	1	D3488-2	BLADE FITTING (RH)		
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT		

\*

D3488-041/-042 BLADE FITTING MATERIAL:

MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR

PER QQ-A-225/9

(REF. DART MATERIAL SPEC M7075T73R)

ACID ETCH, ALODINE PER DART QSI 005 4.1 FINISH:

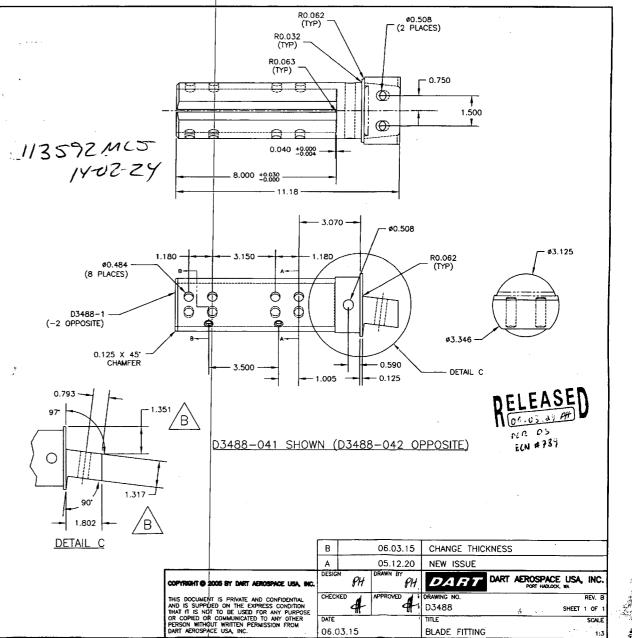
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BREAK UNMARKED SHARP EDGES 0.010 TO 0.020

INSTALL INSERTS AFTER POWDER COAT

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



	DESIGN PH	DRAWN BY	DART AERO	OSPACE USA ORT HADLOCK, WA	, INC.
DART	CHECKED	APPROVED	DRAWING NO. DSK 101		REV. D SHEET 1 OF 1
	DATE 06.05.09	1 4/1	TITLE	IDAMA DETAIL	SCALE
	A A	05.12.21	D3488-1/-2 TU NEW ISSUE	JRNING DETAIL	1:3
	В	06.03.02	ADD TOLERANCE	S AND RADIUS	
a 05.09 th	С	06.04.17	0.188 WAS 0.1		
The second of th	D	06.05.09	REMOVE DIAMET	ER FOR CHAMF	ER
\$3.346 \\ \tag{8.000+0.030} \\ \tag{12.50} \\ \tag{-0.188} \\ \tag{-0.188} \\ \tag{-0.188} \\ \tag{-0.188} \\ \tag{-0.004-0.030} \\ \tag{-0.004-0.030} \\ \tag{-0.188} \\ \tag{-0.004-0.030} \\ \tag{-0.188} \\ \tag{-0.004-0.030} \\ \tag{-0.004-0.030} \\ \tag{-0.188} \\ \tag{-0.188} \\ \tag{-0.004-0.030} \\ \tag{-0.188} \\ \tag{-0.004-0.030} \\ \tag{-0.188} \\ \t	ø3.125	0.040+0.000	CHAMFER CHAMFER		4) ALL DIMENSIONS ARE IN INCHES 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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OR COMMUNICATED TO ANY OTHER F	PERSON WITHOUT	WRITTEN PERMISSI	UN FROM DART AEROSPAC	L USA, INC.	